

Work Order ID 71140

Thursday, June 23, 2011 12:32:40 PM



Page 1

Item ID: D3234-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/23/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-06-23 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3234	Rev B								

100

0.00



FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3234 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

2024 . 050

B11-6-27



110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

B11-6-27

120

0.00



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

8 uloo 627



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6x Ø M-L 11/06/27

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 BL 11-6-27

150

Identify as per dwg & Stock Location

233

0.00



Packaging

Memo

0.00

Packaging

Ry 6/28 06

W/O:		WORK ORDER CHANGES					
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Page 3

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Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/28 JF

me

11-0628

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 12:32:37 PM

Work Order ID: 71140



Parent Item: D3234-1



Parent Item Name: Doubler



Start Date: 6/23/2011

Required Date: 7/5/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 08-08-14 JLM Verified By:EC
IPP Rev:B 08-12-18 as per ECN08-582 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050 		Purchased	No			100	sf	116.3000	0.579	3.656842			
											B11-6-07		

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

116.3

117684

116.3

117684

6

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 71140
Description: Doubler		Part Number: D3234-1
Inspection Dwg: D3234	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001				V B02	
0.300	+/-0.010	304	x		V	
0.250	+/-0.010	257	x		V	
2.270	+/-0.010	2.271	x		V	
2.841	+/-0.010	2.847	x		V	
2.627	+/-0.010	2.630	x		V	
5.993	+/-0.010	5.997	x		V	
7.108	+/-0.010	7.110	x		V	
8.228	+/-0.010	8.230	x		T B01	
10.463	+/-0.010	10.466	x		T	
10.77	+/-0.030	10.785	x		T	
2.251	+/-0.030	2.243	x		V	
13.333	+/-0.010	13.333	x		T	
15.365	+/-0.010	15.365	x		T	
15.665	+/-0.010	15.665	x		T	
2.910	+/-0.010	2.913	x		V	
3.266	+/-0.010	3.268	x		V	
3.495	+/-0.010	3.495	x		V	
3.658	+/-0.010	3.659	x		V	
0.050	+/-0.010	0.049	x		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-6-27	Date: 11/06/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	
B	09.05.04	Dimensions update per Rev B	KJ/DD	

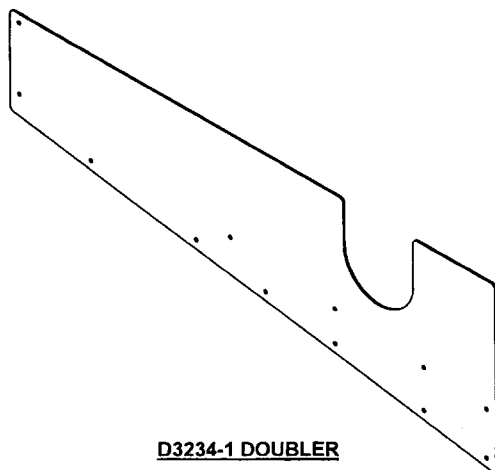
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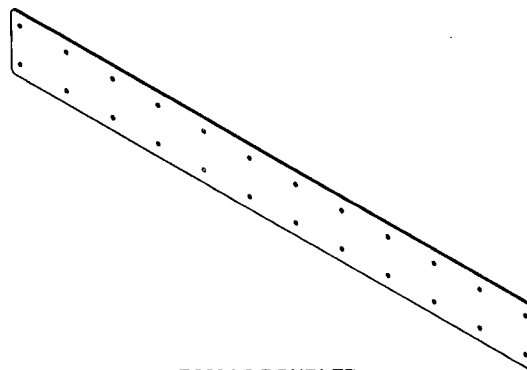
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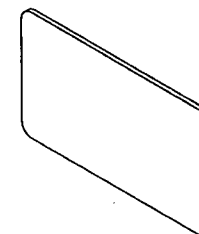
NOTE: Date & initial all entries



D3234-1 DOUBLER



D3234-3 DOUBLER



D3234-5 SPACER

NOTES:

1) MATERIAL: -1 & -3: 2024-T3 ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.050

-5: 5052-H32 ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF DART SPEC M5052H32S.050

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3234-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: -1: 0.30 lbs
-3: 0.15 lbs
-5: 0.01 lbs

RELEASED
08/12/15 NW

B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. PARTS FULLY DIMENSIONED. NO PHYSICAL CHANGES MADE TO PARTS. REASON: REF PAR 08-029.	AJS	08.11.24
A	NEW ISSUE	CP	03.11.19
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	JS	D3234	SHEET 1 OF 2
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	DOUBLER	NTS
DATE	08.11.24	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

71140

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

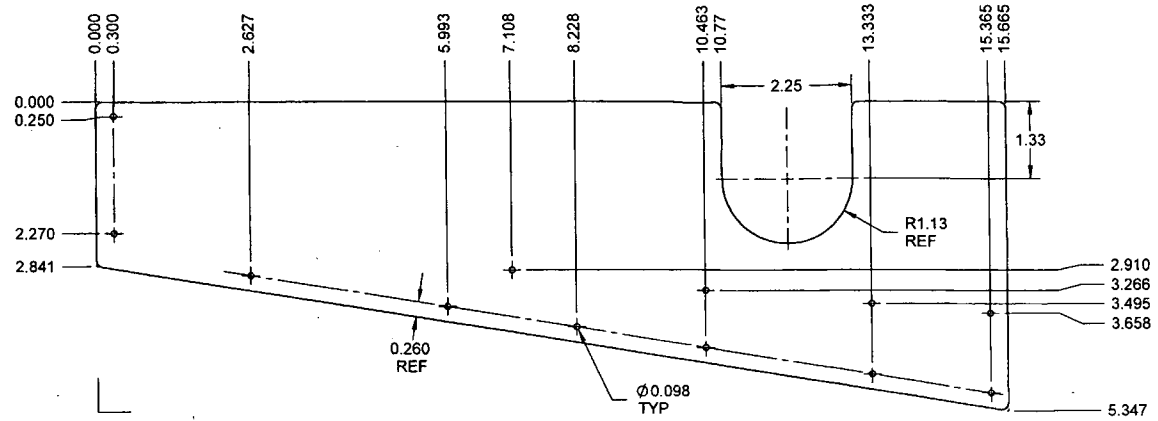
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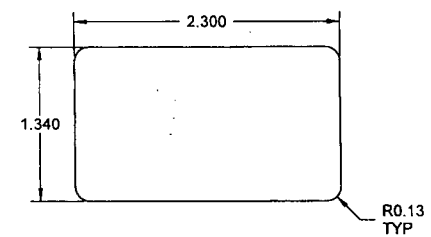
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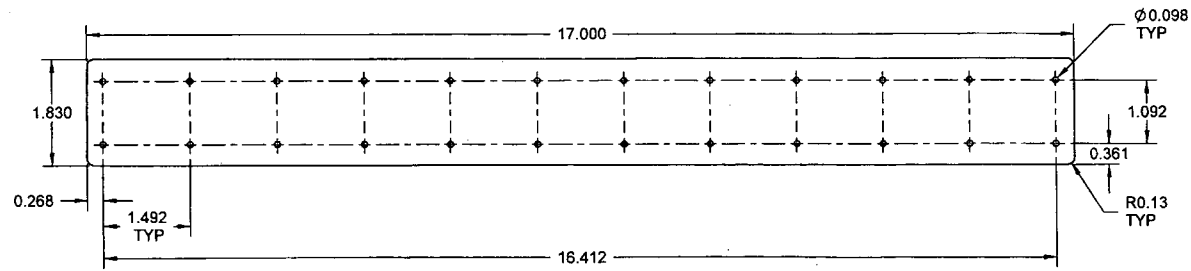
8 7 6 5 4 3 2 1



D3234-1 DOUBLER



D3234-5 SPACER



D3234-3 DOUBLER

#71140

RELEASED
08/12/15

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3234	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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